

Work Order ID 86393

86393

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June-27-12 3:57:52 PM

Item ID: D2607 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket, 206 Console

Start Date: 27/06/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 11/07/2012 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/28 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2607	Rev A1								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2607								
2024.040	Dwg Rev: <u>A1</u>								
	Prog Rev: <u>A1</u>								
	2-Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

6 0 5m 12-7-7

6 0 5m 12-7-7

5/26/09

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2607

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket, 206 Console

Start Date: 27/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Deburr

2-Form as per Dwg D2607

140

0.00

140

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

150

0.00

150

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

SB
12/07/12DAS
16
3-53 12/07/13

(x6)

6 7/16 12-7-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	QC3- Inspect Part Finish	0.00							
155									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <i>812.</i>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MF
12-07-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 86393

86393

Parent Item: D2607

D2607

Parent Item Name: Bracket, 206 Console

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP E02.06.05Added alodine finish TSR 1290NG
IPP Rev:F 07-08-15 Now on WaterJet JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040		Purchased		No		100	sf	178.1612	0.125	0.789474			
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M2024T3S 040

**

1.0

Jm 12-7-7

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

178.1611626

120605

49.6627416

121197

32.498421

122136

96

122136

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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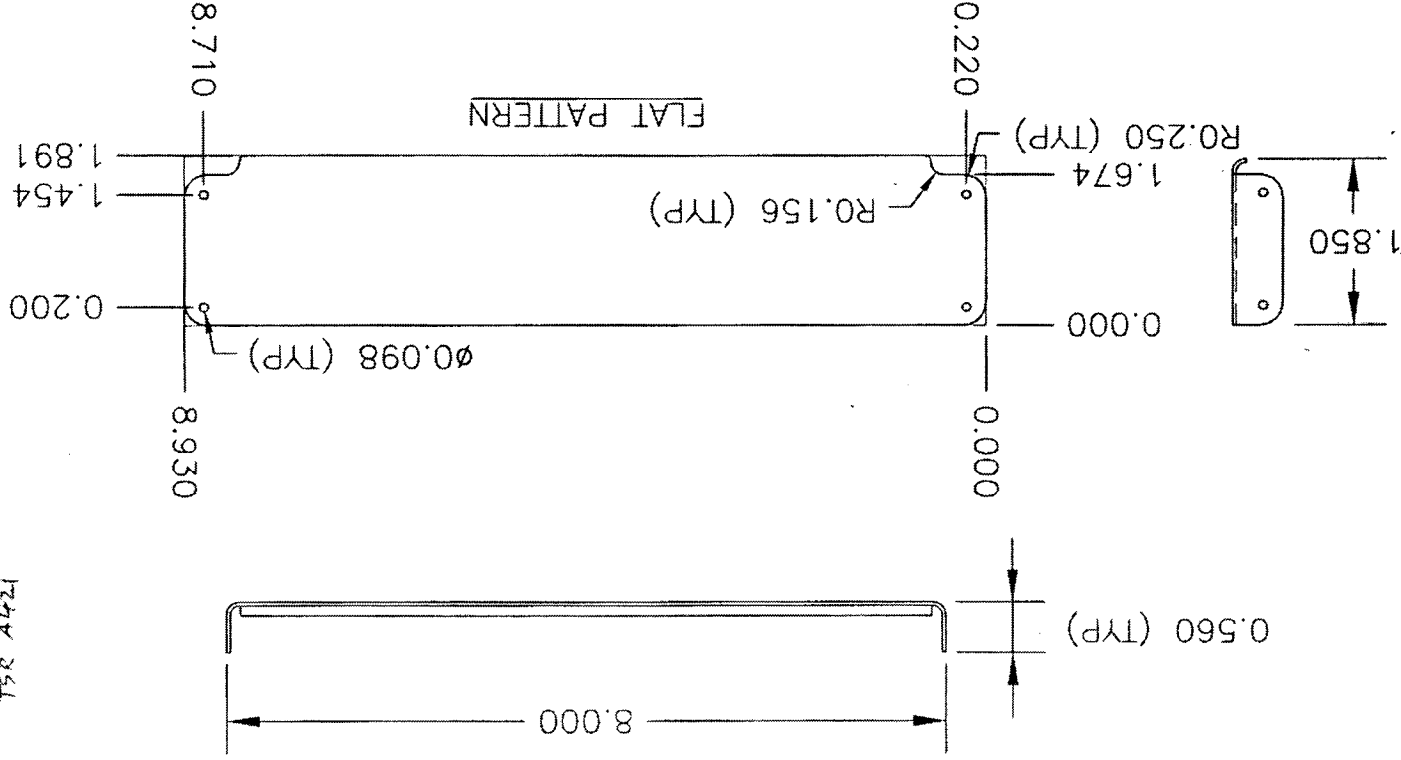


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
KE	[Signature]	D2607	SHEET 1 OF 1
DATE	TITLE		
97.10.23	CONSOLE BRACKET		

A		97.10.23	D2607 WAS D206-547-9
AI	IR	02.06.04	ADD FINISH

RELEASED
97.11.04 KE

TSR A421



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86393 MJS

12/06/28



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2607
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER PART Q5105 4.1

W/O:		WORK ORDER CHANGES					
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